

Work Order ID 69426

Wednesday, May 11, 2011 9:13:40 AM



Page 1

Item ID: D350-607-041

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket, LH

Stop



Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-041 CHG008

~~PRINT TWO COPIES OF 102~~

S. 11/08/11

*J for BG 11-8-10
(LABEL ONLY)*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

JB 11/08/10

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291

Batch: 1117516

Expiry date: 12/31/15

EF 11/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69426

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Page 2

Item ID: D350-607-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

S wlosln



QC

Memo

0.00

Quality Control

*****Ensure label for weight capacity is correct*****



140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

S wlosln

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S wlosln



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 69426

Wednesday, May 11, 2011 9:13:40 AM



Page 3

Item ID: D350-607-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-041 Location: <u> </u>								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

[Signature]
5/11/11

11/8/15
[Signature]
MF
11-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 9:13:51 AM

Page 1

Work Order ID: 69426

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:M 05.09.02 Added D2856-400-720 KJ/JLM

IPP Rev:N 07-12-21 ECN1068 DD

IPP Rev:O as

per ECN10-545 DD 10.04.16 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-241 Basket Clamp Assembly	CHG001	Manufactured	No			140	Each	0.0000	1	1			
D2221 350 Basket Base		Manufactured	No			110	Each	0.0000	1	1			
D2512 Basket Lid 205/350		Manufactured	No			110	Each	0.0000	1	1			
D2022-101 Spacer		Manufactured	No			110	Each	3.0000	2	2			
D2258-200 Placard 200lb		Manufactured	No			110	Each	13.0000	1	1			
D2332-041 Lid Prop Assembly 6.69" long		Manufactured	No			110	Each	0.0000	1	1			

Location

ST504

66939

Loc Qty

3

3

Loc Code

69824

23

Location

ST505

64284

68928

Loc Qty

13

3

10

Loc Code

68928

2099723

11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, May 11, 2011 9:13:51 AM

Page 2

Work Order ID: 69426

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2530

Manufactured No

110 Each

8.0000

1

1 ✓



Handle Weldment



70850 JB

Location

Loc Qty

Loc Code

ST506

8

66563

2

68363

6

D2535

Manufactured No

110 Each

41.0000

2

2 ✓



Spring



71117 JB

Location

Loc Qty

Loc Code

ST504

41

66764

41

D2537

Manufactured No

110 Each

32.0000

2

2 ✓



Bushing



69894 JB

Location

Loc Qty

Loc Code

ST504

32

66972

32

D2728-3

Manufactured No

110 Each

0.0000

2

2 ✓



Dart Logo label



115050 JB

D2931

Manufactured No

110 Each

676.0000

2

2 ✓



Bumper



JB 11/08/10

Location

Loc Qty

Loc Code

ST504

676

46064

676

46064

Wednesday, May 11, 2011 9:13:51 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, May 11, 2011 9:13:52 AM

Page 3

Work Order ID: 69426

Parent Item: D350-607-041


Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011


Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No 110 Each 151.0000 2 2 ✓

 Bolt


Location	Loc Qty	Loc Code
ST352	151	
114752	1	
116419	50	
117441	100	

JB

AN4-7A Purchased No 110 Each 299.0000 2 2 ✓

 Bolt


Location	Loc Qty	Loc Code
ST356	299	
115373	49	
117443	50	
117514	200	

JB

AN4-22A Purchased No 110 Each 242.0000 1 1 ✓

 Bolt

Location	Loc Qty	Loc Code
ST359	242	
114784	92	
116419	50	
117313	100	

JB

AN4-24A Purchased No 110 Each 76.0000 1 1 ✓

 Bolt

Location	Loc Qty	Loc Code
ST359	76	
115835	16	
117514	60	

JB 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Wednesday, May 11, 2011 9:13:52 AM

Page 4

Work Order ID: 69426

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No

110

Each

112.0000

4

4 ✓



Bolt



118422 JB

Location

Loc Qty

Loc Code

ST339

112

116590

32

117313

30

117619

50

AN960JD8 NAS1149DN832J Purchased No

110

Each

0.0000

2

2 ✓



Washer

MU7316



~~118179~~ 118608 JB

AN960JD416 NAS1149D0463J Purchased No

110

Each

0.0000

2

2 ✓



Washer



118179 JB

AN960JD416L NAS1149D0416J Purchased No

110

Each

3.0000

2

2 ✓



Washer



118131 JB

Location

Loc Qty

Loc Code

FP-B

3

110153

3

AN960JD516 NAS1149D0563J Purchased No

110

Each

0.0000

4

4 ✓



Washer



118206 JB 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 9:13:52 AM

Page 5

Work Order ID: 69426

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

110

Each

99.0000

4

4

✓



Washer



117195 JB

Location

Loc Qty

Loc Code

ST344

14

115936

14

ST349

85

116900

35

117317

50

MS20600-AD4W3

Purchased

No

110

Each

1,375.000

2

2

✓



Cherry Rivets



JB

Location

Loc Qty

Loc Code

ST321

1050

111636

350

117505

500

117601

200

WA018

325

107939

325

MS21042L3

Purchased

No

110

Each

2,355.000

2

2

✓



Nut



JB

11/08/10

Location

Loc Qty

Loc Code

ST300

2355

116391

11

116540

378

116549

766

117441

800

117601

400

117441

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 9:13:53 AM

Page 6

Work Order ID: 69426

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,975.000

4

4

✓



Nut



JB

Location

Loc Qty

Loc Code

ST300

4975

116823

1175

117441

3000

117601

800

117441

MS21042L5

Purchased

No

110

Each

1,283.000

4

4

✓



Nut



JB 11/08/10

Location

Loc Qty

Loc Code

ST300

1283

116105

323

116548

260

117441

500

117591

100

117611

100

117591

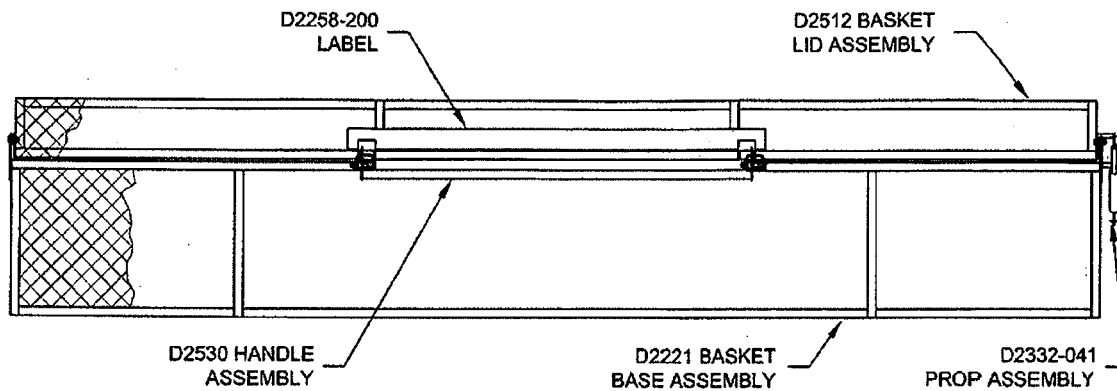
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

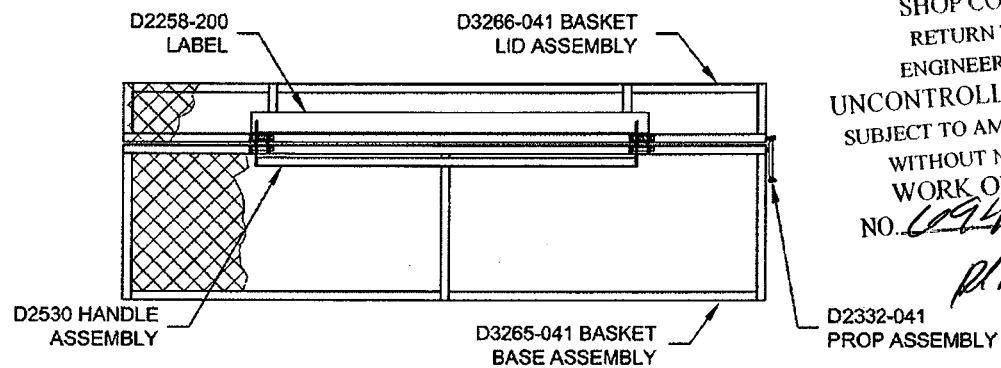
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



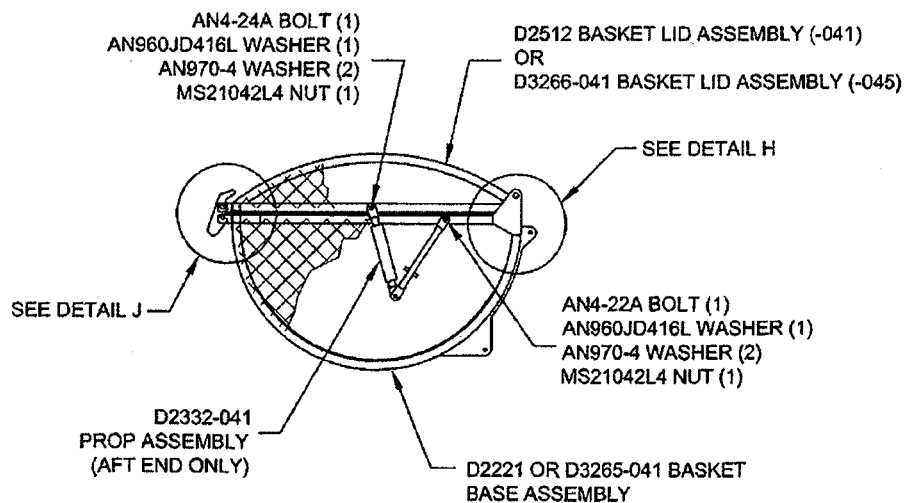
D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 109426

11/11/03-11



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

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Revision: A

Date: 10.03.10

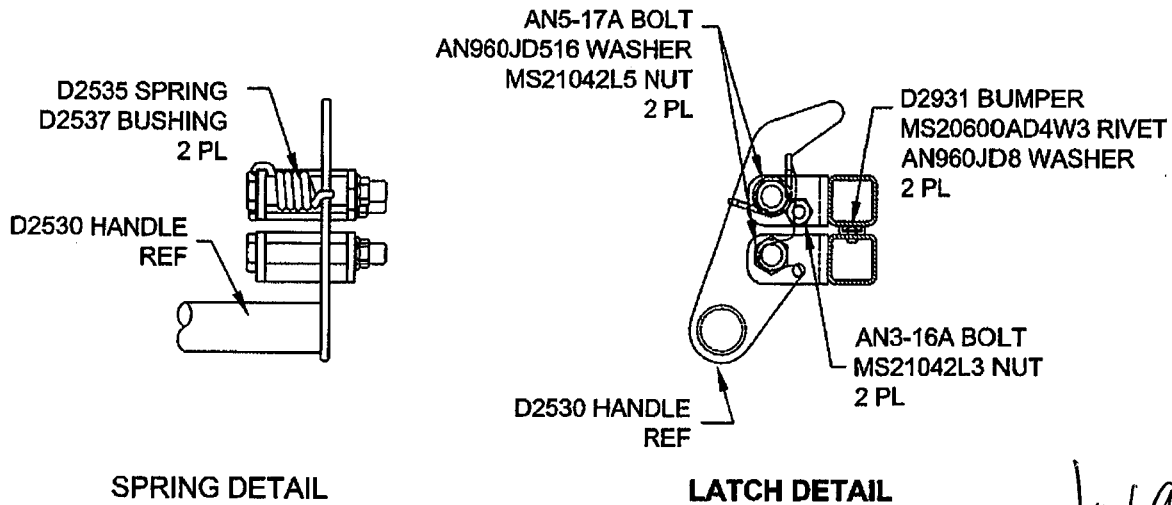
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

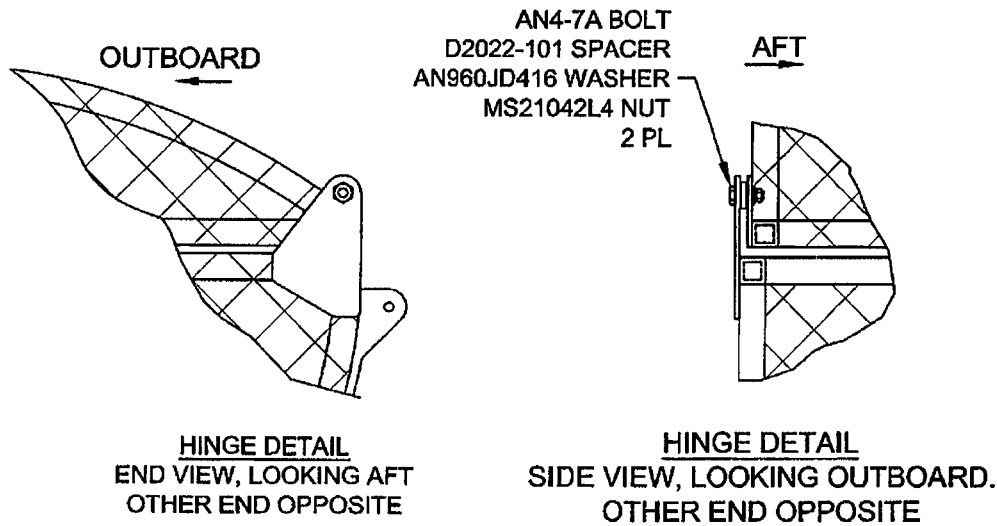
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL J:
HANDLE WELDMENT

u1069426



DETAIL H:
HINGE

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

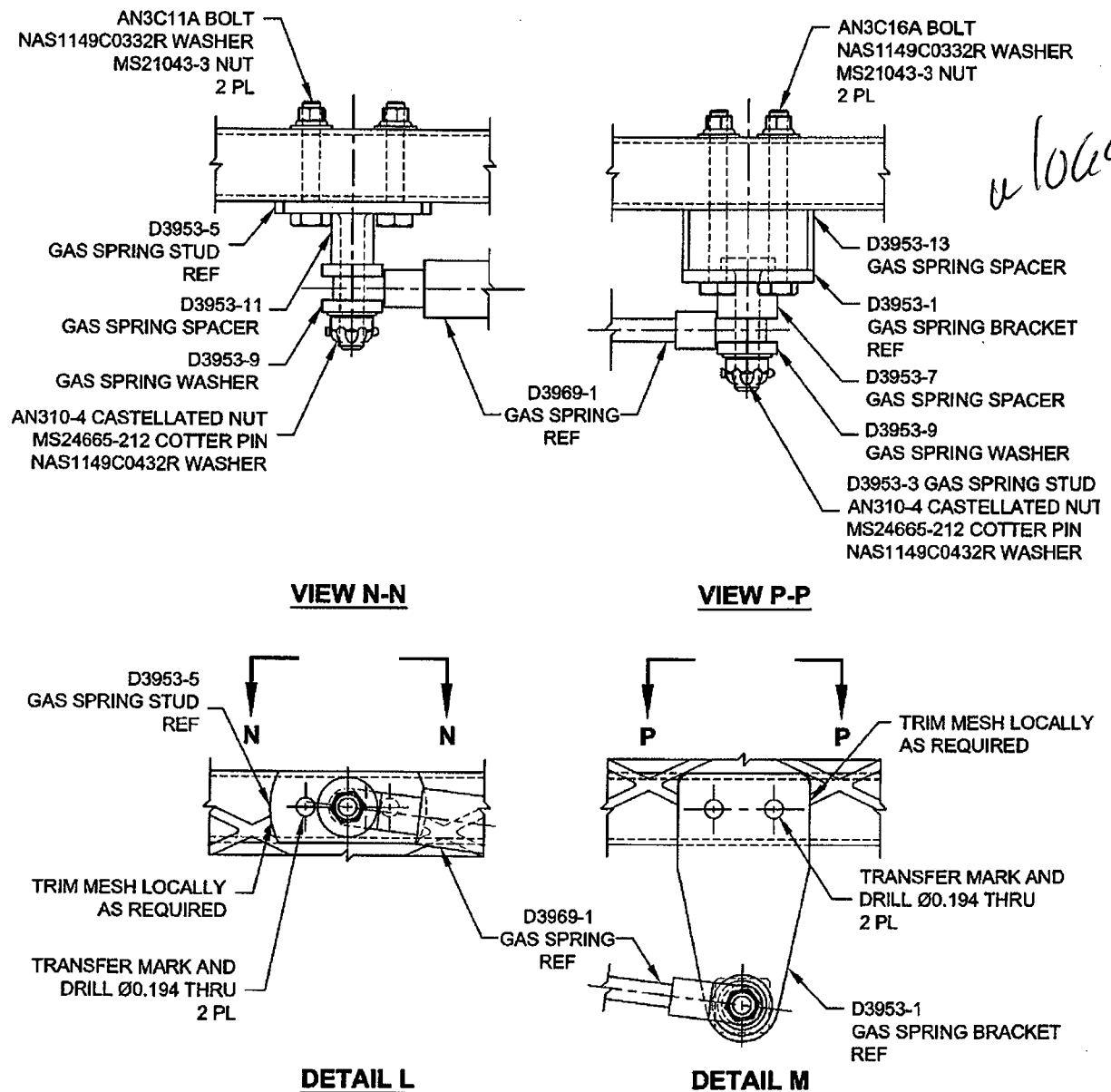


Figure 8b – Automatic Lid Opener Installation

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Revision: A

Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

6.0 PARTS LIST

6.1 D350-607-041/-041A/-043/-043A HELI-UTILITY-BASKET™

Qty -041	Qty -041A	Qty -043	Qty -043A	Qty -241	Part Number	Description
X					D350-607-041	HELI-UTILITY-BASKET
	X				D350-607-041A	HELI-UTILITY-BASKET
		X			D350-607-043	HELI-UTILITY-BASKET
			X		D350-607-043A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
1	1	1	1		D2221	BASKET BASE ASSEMBLY
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1				D2512	BASKET LID ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
		1	1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1				D350-607-141	AUTOMATIC LID OPENER INSTL
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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